

GA 141

1652

SHIP
5-17

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBE350A94-2706-00-01A
Job Sheet 173904

Part No: RBE350A94-2706-00-01A Job Qty: 36 ea

Part Name: Pin Shaft

Part Weight: 0 lbs Status: Scheduled Priority: High

Job Created: 3/8/18 4-23 Created By: Marie Lajeunesse

Due Date: 4/16/18 Type: SOLD Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-15 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	36 Ea	4/13/18	0.00	0.00		Start Up Machining-3		18-6-18
110	CNC Lathe	36 pcs	4/16/18	0.00	18.00		MORI SL-154		
120	QC	36 pcs	4/16/18	0.00	0.00		QC2 Machining-4		
130	QC	36 pcs	4/16/18	0.00	0.00		QC8 Machining-4		18-06-18
140	Packaging	36 pcs	4/16/18	0.00	0.00		Packaging3-1		18-6-22
150	QC21-SA	36 Ea	4/16/18	0.00	0.00		QC21		GA 141

Part Op 110 - 1-Machine as per DWG. FB734 FOLIO REV: AA DWG REV: 6 2-Deburr 3-Engrave Dash 2018

Descriptions: number Using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
88625K65	Dowel Pin Ø6mm x 40mm	36 ft (1 ea)	90-Start up Operation	5039763 = 9

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	88625K65	36	269	0

Part Specifications

Specifications could not be found.

Plex 4/12/18 2:10 PM dart.logan.david



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S081828



Part: RBE350A94-2706-00-01A

Job No: 173904

Serial No/Batch: S081828

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 06/18/18

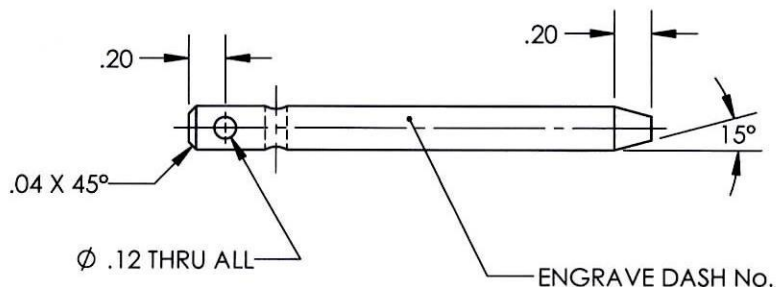
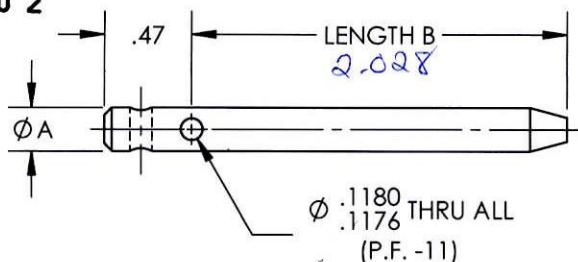
051

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **173904**

20180502

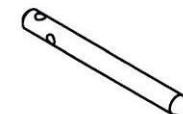
2



-01A, -03A, -05A, -07A, -09A

PIN SHAFT

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -.01 THRU -.09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -.11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	5/26/2015	RJC	RW
4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 +.001/-.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
-01	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01A	REV 6
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01, -03, -05, -07, -09	.XX ± .01 ANGLES ± .6°
SPEC	.X ± .1 SURFACES ± 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 9/11/2009 SHEET 3 OF 3

[illegible]

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					